

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010424**Date Inspected:** 21-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (6AW)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Deck panel U-Rib to diaphragm weld between PP38 and PP39 of 6AW. The weld designations reviewed are as follows:

DP138-001-187, 188

DP138-001-019, 020

DP084-001-059

DP111-001-067, 062, 059, 092

DP165-001-086

DP273-001-056, 051, 048, 038, 084

DP246-001-094, 081, 065, 060

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional survey for offset on T-Rib along with QA inspector (Mr. Manjunath)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

for below segment. Reports forwarded to team leader for further action.

6AE to 6BE (PP40 – PP41)

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AW)

FCAW Process:

Welding of weld joint - 174 located on PCMK SSD25-PP39 of 6AW-FL3. Welder is identified as 220063. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

FCAW Process:

Welding of weld joint - 029 located on PCMK SSD25-PP39 of 6AW-FL3. Welder is identified as 220066. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG # TRIAL ASSEMBLY YARD (2AW-2BW)

SMAW Process:

Welding of weld joint – 002 located on PCMK CA102 of corner assembly longitudinal weld between Deck panel and Edge panel of 2AW-2BW (Crossbeam side). Welder is identified as 044339. ZPMC CWI is identified as Li Yang. Welding was been performed against Critical Welding Repair Report B-CWR907 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint – 004 located on PCMK CA102 of corner assembly longitudinal weld between Deck panel and Edge panel of 2AW-2BW (Crossbeam side). Welder is identified as 054013. ZPMC CWI is identified as Li Yang. Welding was been performed against Critical Welding Repair Report B-CWR907 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint – 004 located on PCMK CA104 of corner assembly longitudinal weld between Deck panel and Edge panel of 2AW-2BW (Crossbeam side). Welder is identified as 044779. ZPMC CWI is identified as Li Yang. Welding was been performed against Critical Welding Repair Report B-CWR907 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.

Summary of Conversations:

The incident report is issued for the above mentioned dimensional discrepancy observed in 5BE. And prior to issue it was informed to ZPMC QC and ABF QA.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
